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D2651-1**Job Sheet 194471****Part No:** D2651-1**Job Qty:** 120 pcs**Part Name:** Plug

300 pcs.

**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/3/19**Job Tracking No:****Due Date:** 5/17/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV B IPP: A 02.04.15 New Issue NG IPP: B**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	120 pcs	5/17/19	5/17/19	0.00	3.13	Hardinge - 1		19/07/19
120	QC 8	120 pcs	5/17/19	5/17/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		mar 19/07/19
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Handfinish - 1-1 Chemical-B4B	120 pcs	5/17/19	5/17/19	0.00	0.24	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		JUL 08 2019

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DAS
65
 9-89

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170 Packaging 3-1 - Stock - B4B

120
pcs

5/17/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
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B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4BPackaging 3 - 33 -
B4BPackaging 3 - 34 -
B4BPackaging 3 - 35 -
B4BPackaging 3 - 36 -
B4B

180 QC 21 - SA

120

5/17/19

0.00 0.00

QC 21 - SA - 21

DAS

21

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pcs		QC 21 - SA - 70	QC 21 - SA - 53
Part Op 100 - Hardinge 1 - Turn as per Folio FA219 and Dwg D2651 Descriptions: 120 - QC8 - Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - Only larger section necessary) 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: () LOCATION : FP001 180 - QC21 - Final Inspection - Work Order Release			
Job BOM			
Part / Item	Component Name	Quantity	Operation
M6061T6R0.500	6061-T6 Round Bar .500"	4.8120 ft (.0401 ea)	100-Hardinge - 1
5157423 5166584 Container			
Job Allocations			
Operation	Component Part	Required	Inventory
100-Hardinge - 1	M6061T6R0.500	5	33
		Allocated	0

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055		
2	Plug	0.375inches ± 0.010	0.385 0.365		
3	Plug	0.050inches ± 0.010	0.060 0.040		
4	Plug	20.000Degrees ± 0.000	20.000 20.000		
5	Plug	0.305inches ± 0.000	0.305 0.303		
6	Plug	0.438inches ± 0.005	0.443 0.433		
7	Plug	0.060inches ± 0.005	0.065 0.055		
8	Plug	0.090inches ± 0.000	0.090 0.088		
9	Plug	0.045inches ± 0.000	0.045 0.043		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S196044



Part: D2651-1

Job No: 194471

Serial No/Batch: S196044

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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